Work Order ID 72425

Monday, July 25, 2011 1:45:25 PM

Rush
mush ship
July 27

Item ID: D3315-3 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Wearplate

Start Date: 7/25/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 7/26/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** // **Date:** 11-07-25 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D3315 / Rev B									
100	FLOW WATER JET	0.00				2			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3315 ☐Dwg Rev: B ☐Prog Rev: B ☐2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				2			
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

11/07/25

11/07/25

11 07 25 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00				(2)			
Brake NC	**Memo**	0.00	SB 11/07/24						
Brake NC	Form using DT8179 Die and DT8157 as per Dwg D3315Rev: B								
140	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00							
Quality Control							11	07	26 (2)
150		0.00							
Large Fab	**Memo**	0.00							
Large Fab	Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev: B ☐Qty Part Number Description Batch☐A/R N/A 7560 Hardcoat Rod M117139						11-7-26		(2)

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Work Order ID 72425

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC10- Inspect visual per QSI004- ground welds	0.00				11.07.27		(2)	
QC	**Memo**	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00				11 07 27		(2)	
QC	**Memo**	0.00							
Quality Control									
180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				2	0	11-7-27.	
Powdercoat	M107338. **Memo**	0.00							
Powder Coating	START TIME: 9:00 ☐OVEN TEMPERATURE: 200 ☐FINISH TIME: 9:30.								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 72425

Monday, July 25, 2011 1:45:25 PM

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Revision ID:

Item Name: Wearplate

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00				2	0		11/07/27
QC	**Memo**	0.00							
Quality Control									
200		0.00							
Packaging	Packaging								11/7/27
Packaging	**Memo**	0.00							
	Identify on inside surface using a permanent fine point marker with the following:□TCCA-PDA, Dart Aerospace Ltd.□P/N: D3315-3, B/N: BXXXXX□For Product Eligibility see PDA04-17□and Stock□Location: 19b								
210	QC21- Final Inspection - Work Order Release	0.00							11/7/27
QC	**Memo**	0.00							
Quality Control									11/07/27

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 1:45:31 PM

Work Order ID: 72425

Parent Item: D3315-3

Parent Item Name: Wearplate

Start Date: 7/25/2011 **Required Date:** 7/26/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP: A□05.05.12□New issue□KJ/JLM□
IPP Rev:B As per Rev B 06-03-24 JLM
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			100	sf	150.5000	2.296	4.833684			
1010/1025 sheet 16GA													

Location	Loc Qty	Loc Code
MAT019	150.5	
116791	32.5	
117500	118	

5.10 RO 11/07/25

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72425
Description: Wearplate	Part Number:	D3315-3
Inspection Dwg: D3315 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.75	+/-0.030	62.75	✓		RA04	TAPE
58.094	+/-0.010	58.100	✓		"	
51.368	+/-0.010	51.370	✓		"	
44.531	+/-0.010	44.530	✓		"	
37.719	+/-0.010	37.720	✓		"	
36.375	+/-0.010	36.375	✓		"	
24.188	+/-0.010	24.187	✓		"	
18.875	+/-0.010	18.875	✓		"	
17.375	+/-0.010	17.375	✓		"	
10.594	+/-0.010	10.600	✓		"	
5.375	+/-0.010	5.375	✓		"	
0.875	+/-0.010	.875	✓		"	
1.62	+/-0.030	1.625	✓		RA04	TAPE
5.214	+/-0.010	5.206	✓		RA26	Vern
4.402	+/-0.010	4.404	✓		"	"
3.550	+/-0.010	3.560	✓		"	
Ø0.300	+0.006/-0.001	.301	✓		"	
Ø0.266 x 0.450	+/-0.010	.267 x .453	✓		"	Vern
30.969	+/-010	30.969	✓		RA04	TAPE

11-07-25

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/07/25	Date:	11.07.25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	

Dart Aerospace Ltd

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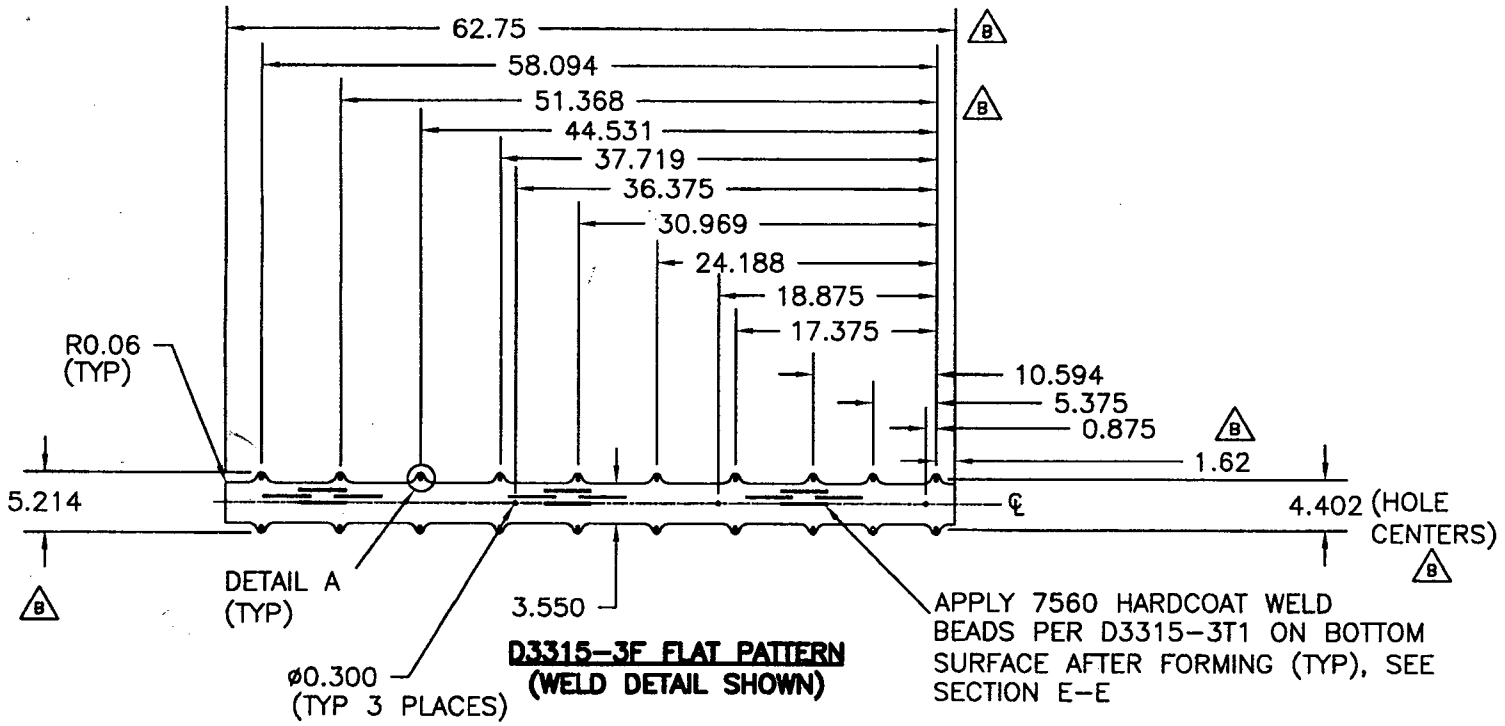
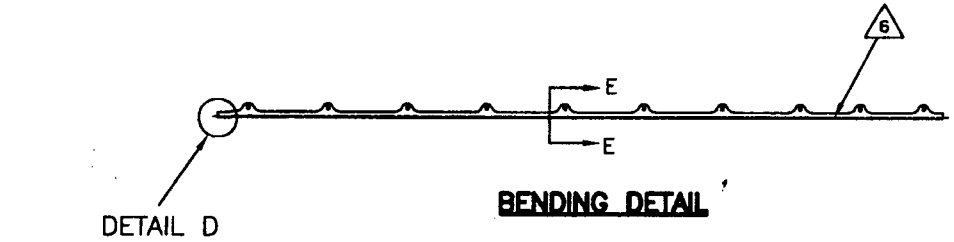


D3315-3F FLAT PATTERN
(WELD DETAIL SHOWN)



BENDING DETAIL

RELEASED
06.03.20

D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
3) WELD PER DART QSI 004
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY ON INSIDE SURFACE AS INDICATED "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3315	REV. B
DATE 06.01.31		TITLE WEARPLATE	SCALE 1:16
			SHEET 2 OF 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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